

Date: Tuesday, 28/10/2008 2:32:08 PM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE
Job Number : 43018	
Estimate Number : 13568	
P.O. Number :	
This Issue : 28/10/2008 S.O. No. :	Part Number : D38143
Prsht Rev. : NC	Drawing Number : D3814 PREL
First Issue : / /	Project Number : N/A
Previous Run : 42055	Drawing Revision : PREL
Type : MACHINED PARTS	Material :
Written By : <u>JLM 08-10-28</u>	Due Date : 04/11/2008 Qty: 2 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 08-09-03 JLM Verified By: <u>SO</u>	

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6B2000X03500 6061-T6 Bar 2.00 x 3.50



Comment: Qty.: 0.4150 f(s)/Unit Total: 0.8299 f(s)

6061-T6 Bar 2.00" X 3.500"

BATCH: M16391

J.L. 08/10/28

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 4.75" long

J.L. 08/10/28

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA780 Rev: AA & Dwg D3814 Rev: A

2-Deburr per dwg D3814

3-Finish tapping hole to final depth as per Dwg D3814

H.A. 08/10/30

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A. 08/10/30

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ENGINEERING  
APPROVAL

08.11.02.

JLM 08-10-30

User: Jean-Luc Menard

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE

Job Number: 43018

Part Number: D38143

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS

08-10-31

(X2)

7.0

POWDER COATING

POWDER COATING



M109152



(2X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

\*\*\*MASK THREADED HOLE PRIOR TO POWDER COAT\*\*\*

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:15  
320 OF  
8:45

M-L 08/10/31

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/10/31

(2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

u 08-10-31

2

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-10-31  
POSITIVE RECALL  
EFFECTIVE 08-10-28 AUTH  
RELEASED DATE

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43018
<b>Description:</b> HINGE		<b>Part Number:</b> D3814-3
<b>Inspection Dwg:</b> D3814 Rev: A <i>Prelim</i>		Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

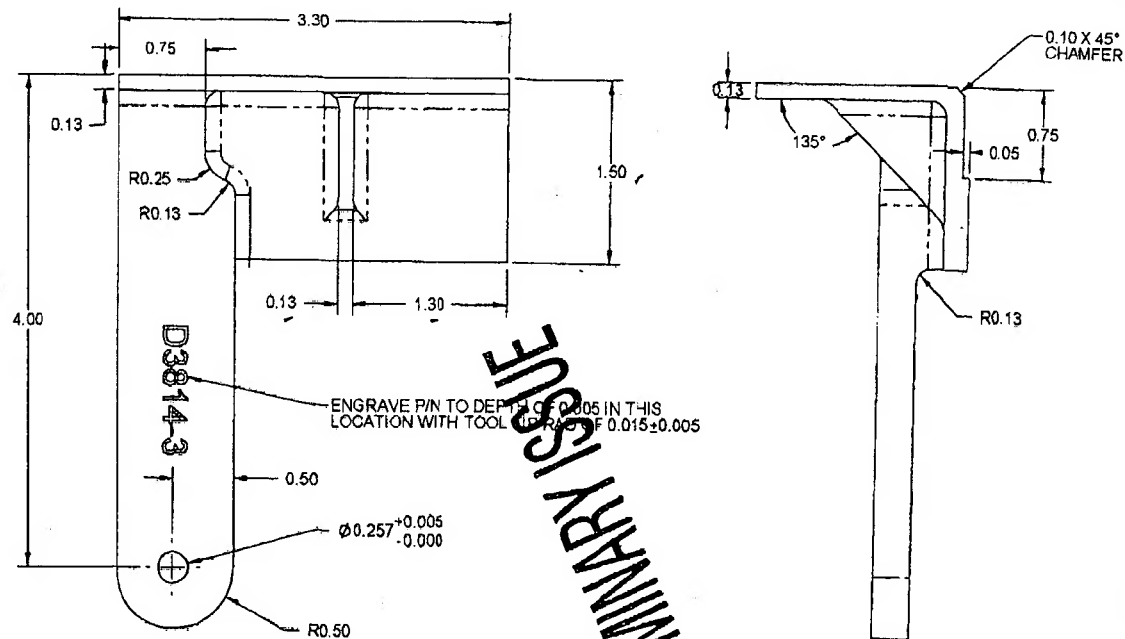
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.30	+/- .030	3.301	✓			
0.75	+/- .030	0.750	✓			
0.13	+/- .030	0.127	✓			
R0.25	+/- .030	R0.25	✓			
R0.13	+/- .030	R0.13	✓			
4.00	+/- .030	4.000	✓			
R0.50	+/- .030	R0.50	✓			
0.50	+/- .030	0.501	✓			
0.257	+0.005 / - .000	0.260	✓			
1.00	+/- .030	1.001	✓			
0.75	+/- .030	0.748	✓			
0.05	+/- .030	0.050	✓			
1.00	+/- .030	0.997	✓			
R0.13	+/- .030	R0.13	✓			
0.21	+/- .030	0.212	✓			
1.05	+/- .030	1.05	✓			
1.81	+/- .030	1.807	✓			
0.13	+/- .030	0.126	✓			
0.75	+/- .030	0.747	✓			
R0.13	+/- .030	R0.13	✓			
0.10 x 45°	+/- .030	0.098 x 45°	✓			
0.05	+/- .030	0.050	✓			
135°	+/- 1/2°	135°	✓			

<b>Measured by:</b> N.A.	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b> <i>[Signature]</i>
<b>Date:</b> 08/10/30	<b>Date:</b> 08.10.30	<b>Date:</b> 08.11.02

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D3814-3 HINGE, LOWER AIRFRAME****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/415/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3814	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	08.10.27	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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